

Work Order ID 72094

Tuesday, July 19, 2011 10:23:37 AM



Page 1

Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 7/19/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/5/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: H Date: 11-07-19

Tooling:

Date:

Run Start

QC: Date: SPC (Y/N): Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2580-041

Rev.D DEO-D1

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG004

stop 220

110

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend I

Memo

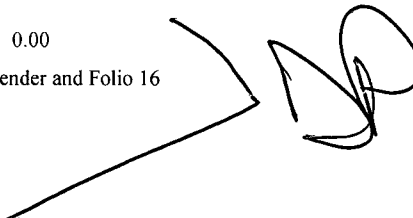
0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio 16

2-Cut tubes as per Dwg. D2580

3- scribe batch# in aft end of tube

11-7-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

0.00



Skidtubes

Memo

0.00

Skidtubes

1- Deburr ends and remove bending marks

2- Prepare tube for swaging as per QSI 002

3

11/07/21

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

1 8 8611/02/25

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Weld step D2576 as per Dwg. D2580 and QSI 004

A/R □ □ □ Aluminum Rod

M115778

BE 11/07/26

2-Grind welds on step as per Dwg D2580

3-Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002 and dwg. Hold x-bolt with DT9701 Use tube expander 1/2 x 17G to start expansion and finish with 1/2 x 18G to achieve dwg dimension.

WELDED
A/R M115778

BE 11/07/26

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64", adjust stopper not to hit web. Debur

Sh 11/07/26

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Debur

BE 11/07/27

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Debur

150

0.00



QC

QC10- Inspect visual per QSI004- ground welds

Memo

0.00

Quality Control

K 11-07-28

1-0

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Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

11 07 28 (1)

170

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.

1 0 11/08/01

180

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:00
320 OF
1:30

IX 0 M-11/08/02

M117745

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 0 22 1109103

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Page 6

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Reference:

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Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

0.00



HandFinish

Hand Finishing

Memo

0.00

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates

A/R ☐ ☐ ☐ Sikaflex-291 ☐ ☐ ☐ M 117 516

Sikaflex expire date: 01/15

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R ☐ ☐ ☐ Sikaflex-291 ☐ ☐ ☐ M 117 516

Sikaflex expire date: 01/15

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

Batch:

M 118313

IX ~~Ø~~ M 11/08/03

W/O:		WORK ORDER CHANGES					
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Page 7

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Cust Item ID:

Required Date: 8/5/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

S wlosky

(40)

220

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD205-634-041

Location: _____

PPP Rev: _____

PPP 72094

P-41/8 C

230

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 4/08/09

11-08-8
(1)

W/O:		WORK ORDER CHANGES					
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Picklist Print

Tuesday, July 19, 2011 10:23:44 AM

Page 1

Work Order ID: 72094

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube




Start Date: 7/19/2011

Required Date: 8/5/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30
KJ IPP Rev P 10.02.19
per PAR09-043 EC verified by:DD
IPP Rev. O 06.02.28 Added paperwork EC
IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM IPP Rev:Q
10.12.01 as per chg003 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4202-1  Spacer	<i>D2579</i>	Manufactured	No			140	Each	443.0000	20	20			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>LG002</div> <div>443</div> <div></div> </div>													
<div> <div>66929</div> <div>106</div> <div></div> </div>													
<div> <div>67129</div> <div>196</div> <div></div> </div>													
<div> <div>67308</div> <div>1</div> <div></div> </div>													
<div> <div>67430</div> <div>140</div> <div></div> </div>													
D2580-1  205 Skidtube bent detail		Manufactured	No			110	Each	1.0000	1	1			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>LG</div> <div>2</div> <div></div> </div>													
<div> <div>71014</div> <div>2</div> <div></div> </div>													
<div> <div>ST046</div> <div>1</div> <div></div> </div>													
<div> <div>70785</div> <div>1</div> <div></div> </div>													
D2576-3  Step (maching detail)		Manufactured	No			140	Each	44.0000	1	1			
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
<div> <div>LG</div> <div>44</div> <div></div> </div>													
<div> <div>66156</div> <div>44</div> <div></div> </div>													

BE 11/07/25
B 72/99 x 20

11-7-20

BE 11/07/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 2

Work Order ID: 72094

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 7/19/2011

Required Date: 8/5/2011

Start Qty: 1.00

Required Qty: 1.00

D2855 Manufactured No 200 Each 39.0000
Cap



1 1
m-k 11/08/03

Location	Loc Qty	Loc Code
FP007	39	
53791	4	
65519	2	
65569	33	

AN3-5A Purchased No 200 Each 1,055.000
Bolt

Location	Loc Qty	Loc Code
ST350	1055	
115371	279	
117423	776	

2 2
m-k 11/08/03

AN960JD10L NAS1149D0332J Purchased No 200 Each 0.0000
Washer
ALS7-1032-130 Purchased No 200 Each 1,075.000
Insert

Location	Loc Qty	Loc Code
ST282	1075	
117717	1075	

2 2
2x m-k 11/08/03

50 50
m-k 11/08/03

m 117087

m 118386

50x

W/O:		WORK ORDER CHANGES					
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Tuesday, July 19, 2011 10:23:45 AM

Page 3

Work Order ID: 72094

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 7/19/2011

Required Date: 8/5/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C4A Purchased No 200 Each 1,552.000 50 50
BOLT

Location	Loc Qty	Loc Code
ST350	1552	
117313	2	
117688	488	
117795 ✓	500	
117872	22	
118012	500	
118112	40	

m-l 11/08/03

AN960C10L NAS1149C0332 Purchased No 200 Each 0.0000 50 50
R



washer

D3566-13



Gasket

Manufactured No

Location	Loc Qty	Loc Code
FP	20	
69281 ✓	20	
FP014	1	
68341	1	

D3566-5 Manufactured No 200 Each 20.0000 1 1



Gasket

Location	Loc Qty	Loc Code
FP015	20	
68961 ✓	8	
71601 ✓	12	

50X m-l 11/08/03

m-l 11/08/03

1X

m-l 11/08/03

1X

Tuesday, July 19, 2011 10:23:45 AM

Shop Packet Print

Page 3

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Start Date: 7/19/2011

Required Date: 8/5/2011

Start Qty: 1.00

Required Qty: 1.00

D3566-1 Manufactured No 200 Each 32.0000 2 2
Gasket

Location	Loc Qty	Loc Code
FP011	30	
70769 ✓	18	
71580	12	
FP015	2	
68924	2	

m-l 11/08/03

2x

D3564-11 Manufactured No 200 Each 4.0000 1 1
Wearshoe

Location	Loc Qty	Loc Code
FP019	4	
67591 ✓	4	

m-l 11/08/03

1x

D3564-13 Manufactured No 200 Each 22.0000 1 1
Wearshoe

Location	Loc Qty	Loc Code
FP016	11	
69280	11	
FP017	11	
71594 ✓	11	

m-l 11/08/03

1x

D3564-9 Manufactured No 200 Each 9.0000 1 1
Wearshoe

Location	Loc Qty	Loc Code
FP019	9	
67590 ✓	4	
69943 ✓	5	

m-l 11/08/03

1x

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Required Date: 8/5/2011

Start Qty: 1.00

Required Qty: 1.00

D3564-5

Manufactured No

200

Each

19.0000

1

1



Wearshoe

Location

Loc Qty

Loc Code

FG

2

34806

2

FP019

17

70864 ✓

17

D2594-3

Manufactured No

200

Each

780.0000

16

16



O-Ring, 205 Skidtube

Location

Loc Qty

Loc Code

FP-A

780

65518 ✓

54

66952 ✓

726

D2594-1

Manufactured No

200

Each

233.0000

16

16



Plug, 205 Skidtube

Location

Loc Qty

Loc Code

FP-A

233

42807

28

67441 ✓

7

68943 ✓

198

m-11/08/03

IX
m-11/08/03

16x
m-11/08/03

16x

W/O:		WORK ORDER CHANGES					
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DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED
07.06.28 *PH*

DEO ATTACHED

UNDER REVIEW

PH 11.06.90

RMV PH 11.06.90

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. *72094*

PH 11-07-19

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

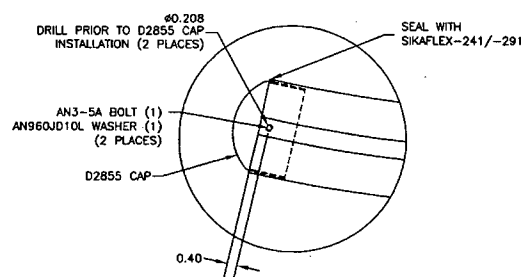
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

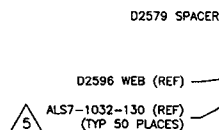
RMV 4.10.30



DETAIL C
SCALE 5:24



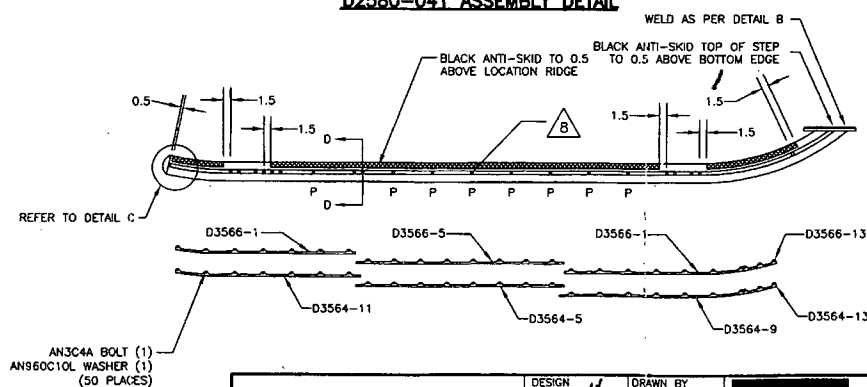
D2579 SPACER



AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR #0.508 HOLES ONLY:

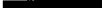
1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO $\phi 0.437$ X 1.00 DEEP

D2580-041 ASSEMBLY DETAIL



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- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

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THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		CHECKED #	APPROVED #	DRAWING NO. D2580	REV. SHEET 2 OF
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY		SCALE 1:2	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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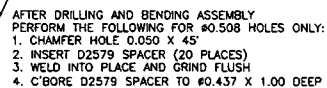
AP 11.06.30
RMV AP 11.06.30



RMV 6P4.06.30



D2579 SPACER



Elevation view of the bridge deck showing reinforcement details. The drawing includes dimensions and callouts for various components:

- Top Left:** A dimension of 37.50 indicates the distance from the left edge to the centerline of the D2596 web.
- Web Reinforcement:** Two triangles labeled "3" and "7" are shown near the top left corner.
- Deck Thickness:** Dimensions of 8.750, 17.375, 26.000, and 34.188 are shown along the bottom edge, indicating different levels or sections of the deck.
- Reinforcement Bars:** A circle highlights a section of the deck where reinforcement bars are located. A dimension of 1.750 is shown between two vertical lines.
- Bottom Edge:** A dimension of 38.0 is shown at the far left, and a total length of 91.500 is indicated at the bottom right.
- Right Side:** A dimension of 57.313 (REF) is shown, followed by the note "7 EQUAL SPACES 8.188 PITCH".
- Callouts:** "REFER TO DETAIL A" points to the first circle, and "REFER TO DETAIL E" points to the second circle.
- Notes:** "#0.508 (TYP.) (40 PLACES)" is noted near the second circle.
- Bottom Center:** The identifier "(D2500-1)" is present.

Side elevation view of the bridge deck. Dimensions include: 5.985, 1.4, 5.338 (REF), 51.340, 39.580, 5.915, 3.630 (REF), 20.0, 11, 1.0, 13.4, 1.0, 32.0 ± 1.0. Hole specifications: #0.508 (8 PLACES), #0.640. Callouts: 4, 11. Text: (MAKE FROM D2350-1 DRILLING DETAIL), DISTANCE BETWEEN HOLE AND TANGENT POINT.


[illegible]

i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE
WITH THE SPACER AT THIS LOCATION

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CHECKED	
DATE	07.02.27

	APPROVED 
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DRAWING NO.
D2580

REV. D
SHEET 3 OF 3

	TITLE
	DOE SKI

TITLE	205 SKIDTUBE ASSEMBLY
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REV. D
SHEET 3 OF 3
SCALE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Linda Lacelle

From: dshepherd@dartaero.com
Sent: April 18, 2011 11:36 AM
To: Linda Lacelle; Mike Petsche
Cc: Bill Beckett; 'Chris Provencal'; 'Eric Charbonneau'
Subject: Re: Alum. Solution Anneal - swaging

Makes sense to me ... We don't want to get caught short ... Make sure that if we do this, they are ident. the old CHG number.

David

Sent from my BlackBerry device on the Rogers Wireless Network

From: "Linda Lacelle" <llacelle@dartaero.com>
Date: Mon. 18 Apr 2011 11:21:10 -0400
To: 'Mike Petsche' <mpetsche@dartaero.com>; <dshepherd@dartaero.com>
Cc: 'Bill Beckett' <bbeckett@dartaero.com>; 'Chris Provencal' <cprovencal@dartaero.com>; 'Eric Charbonneau' <echarbonneau@dartaero.com>
Subject: RE: Alum. Solution Anneal - swaging

- I am ready to weld some up, I don't want to get into trouble with L/T's on these, any objections??
LL

From: Mike Petsche [mailto:mpetsche@dartaero.com]
Sent: April 18, 2011 10:42 AM
To: 'Linda Lacelle'; dshepherd@dartaero.com
Cc: 'Bill Beckett'; 'Chris Provencal'; 'Eric Charbonneau'
Subject: RE: Alum. Solution Anneal - swaging

Well I'm not sure what to say.

It is my understanding that the swaging will still make sense even with the extra hoops we need to jump through if there is still uncertainty on the delivery of the material, we CAN still weld them if we need to.

And while this might be less than "world class", couldn't we take some of our tubing that we have in stock and with the welder to knock down the temper a little? Ground clamp on one end, torch on the other.....BZZZZZZ?

(I'm only sort of joking.....because I bet it would work)

From: Linda Lacelle [mailto:llacelle@dartaero.com]
Sent: April 18, 2011 9:44 AM
To: dshepherd@dartaero.com; 'Mike Petsche'
Cc: Bill Beckett; Chris Provencal; Eric Charbonneau
Subject: RE: Alum. Solution Anneal - swaging
Importance: High

NO. 258

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: B69986
Part number: 205-634-041
Description: 205
Welding Process: Tig[☒] Mig[]
Base material: Aluminum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Pat. Evers Date of Test Coupon 11.06.24
Welder Barclay Elliot Date of Test Coupon 11/06/24

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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